

Date: Wednesday, 10/09/2008 3:41:10 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MAINTENANCE STEP, RH
Job Number	: 41941		
Estimate Number	: 11284		
P.O. Number	:	Part Number	: D3436044
This Issue	: 10/09/2008 S.O. No. :	Drawing Number	: D3436 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 39507	Material	:
Written By	:	Due Date	: 20/09/2008 Qty: <i>1</i> Um: Each
Checked & Approved By	: <i>JLD 08.9.10</i>		
Comment	: EsT A 05.05.11 New Issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34361	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

1	D3436-1	Clamp	<del>AA17679</del> B41943
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*12.08.09.15* \$

2.0	D34364	Right Step
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

RH Step

Pick:

Qty Part Number Description Batch

1	D3436-4	RH Step	B41495
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*12.08.09.15* \$

3.0	D34365	Bushing
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Pick:

Qty Part Number Description Batch

4	D3436-5	Bushing	B23357
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*12.08.09.15* \$

4.0	D34367	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cap

Pick:

Qty Part Number Description Batch

1	D3436-7	Cap	B33196
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*12.08.09.15* \$

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 10/09/2008 3:41:10 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAINTENANCE STEP, RH

Job Number: 41941

Part Number: D3436044

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and Dwg D3436 Dwg Rev:

A

Qty Part Number Description Batch

A/R/N/A 4130 Welding Rod M102226

Weld right step D3436-4 using welding Jig DT8773 and Dwg D3436 Dwg Rev: A

Qty Part Number Description Batch

A/R/N/A 4130 Welding Rod M102226

Weld cap D3436-7 as per Dwg D3436 Dwg Rev: A

Qty Part Number Description Batch

A/R/N/A 4130 Welding Rod M102226

*08.09.16*

6.0

BAND SAW

BAND SAW



Comment: BAND SAW

Slit part D3436-041 on bandsaw as per Dwg D3436

*08.09.16*

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*08-09-16*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08/09/16*

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Deburr

*N/A Do at step 5*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4

*M108496 FL 08/09/16*

START TIME: 12:45pm

OVEN TEMPERATURE: 400°F

*08-09-16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 10/09/2008 3:41:10 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAINTENANCE STEP, RH

Job Number: 41941

Part Number: D3436044

Job Number:



Seq. #:

Machine Or Operation:

Description:

FINISH TIME:

1:15pm

08-09-16 x 1/3H

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*CP 08/09/17 @*

12.0

D34369

Pad



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pad

Install pad using contact cement as per manufacturer's instructions and Dwg D3436

Dwg Rev: A

Pick:

Qty Part Number Description Batch

2 D3436-9 Pad

A/R N/A Contact Cement

*35490 08/09/17 @  
1109109 08/17 (1)*

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/09/18 @*

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*CP 08/18 (1) PP 41940*

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/09/18 @*

Job Completion



*W 08.09.18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

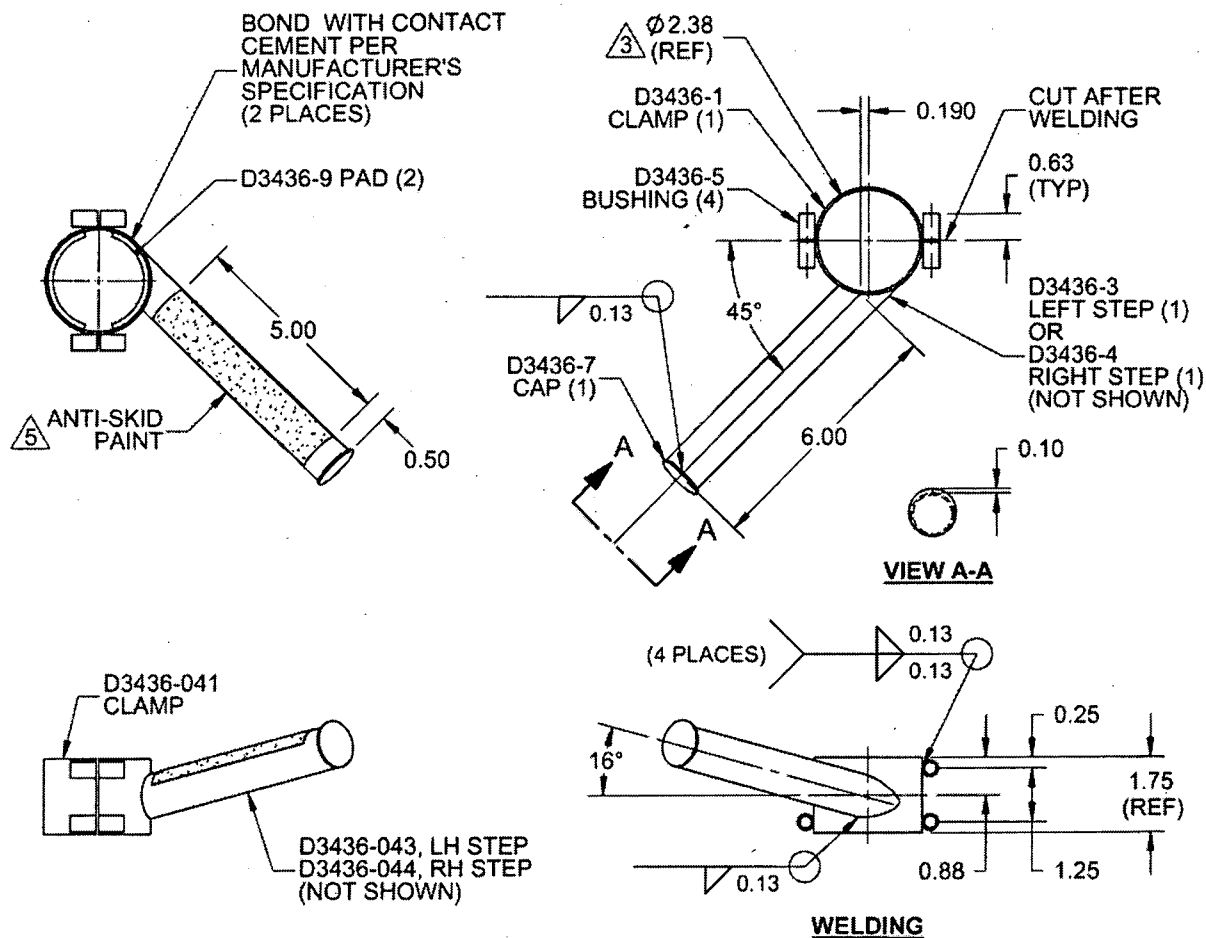
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

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CHECKED #	APPROVED #	DRAWING NO. <b>D3436</b>	REV. A SHEET 1 OF 4
DATE <b>05.04.28</b>		TITLE <b>MAINTENANCE STEP</b>	SCALE 1:4
A	05.04.28	NEW ISSUE	

**NOTES:**

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

05-05-27

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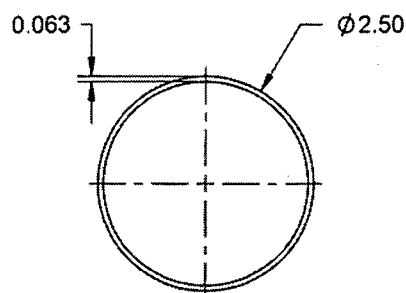
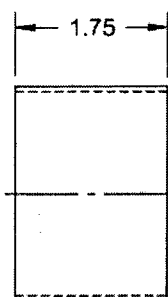
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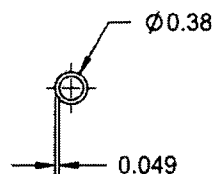
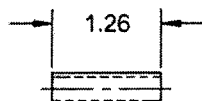


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CHECKED H	APPROVED H	DRAWING NO. D3436	REV. A SHEET 2 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2



#### **D3436-1 CLAMP**

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



#### **D3436-5 BUSHING**

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

#### **D3436-1/-5, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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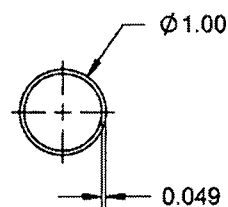
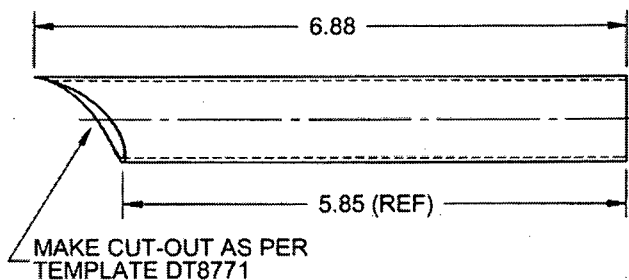
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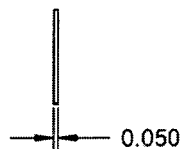
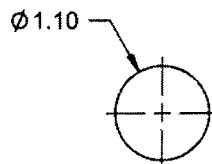
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DATE <b>05.04.28</b>	TITLE <b>MAINTENANCE STEP</b>		SCALE 1:2

**D3436-3 LEFT STEP**

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)

**D3436-7 CAP**

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

**D3436-3/-7, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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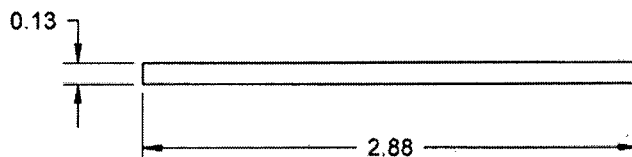
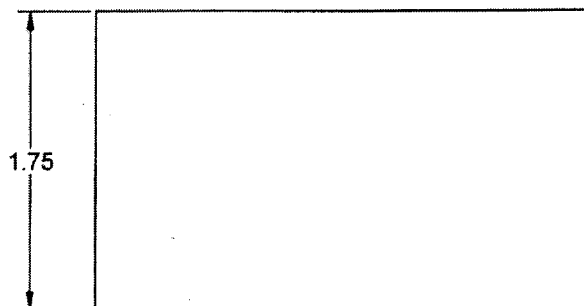
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DATE <b>05.04.28</b>		TITLE <b>MAINTENANCE STEP</b>	SCALE 1:1



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05-05-27 *MB*

**D3436-9 PAD**

**NOTES:**

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK  
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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